



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6405G02131-

3G

Job Sheet 190218



Part No: RBW6405G02131-3G

Job Qty: 2 pcs

Part Name: Tail Rotor Blade Damper Attachment Bushing Removal



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/6/19

Job Tracking No: SIOP

Due Date: 3/15/19

Created By: Dara Macdonald

Type: Stock

Description:

Note: DWG RBW6405G02131-3G Rev D IPP Rev.A 17.08.29 New issue DP Verify DD IPP Rev B 17.11.14 Rev Rev B DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	2 pcs	3/15/19		0.00	0.67	Small Fab - 1		HLC
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	2 pcs	3/15/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	2 pcs	3/15/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		



Container No: S164488



Part: RBW6405G02131-3G

Job No: 190218

Serial No/Batch: S164488

Revision: D

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/20/19

MAR 20 2019

DAS
40
9-89

				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	DAS
				Packaging 3 - 7 - B4B	28
				Packaging 3 - 8 - B4B	9-89
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - FG	2 pcs	3/15/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70
					QC 21 - SA - 53

DAS
21
9-89

MAR 21 2019

Part Op 110 - (Small Fab) 1- Assemble as per DWG RBW6405G02131-3G
 Descriptions: 120 - (QC5- Inspect part completeness to step on W/O)
 130 - (Identify as per dwg & Stock Location: _____)
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
94191A150	Hex Nut 1/4-28 UNF	2 pcs (1 ea)	110-Small Fab - 1	3132374
95229A420	Flat Washer	2 pcs (1 ea)	110-Small Fab - 1	5016491
RBW6405G02131-3G-1	Bolt	2 pcs (1 ea)	110-Small Fab - 1	5158538
RBW6405G02131-3G-3	Bell	2 pcs (1 ea)	110-Small Fab - 1	1Y 503028 2Y 5093944
RBW6405G02131-3G-5	Quarter Bell	4 pcs (2 ea)	110-Small Fab - 1	5159210
				8262

Job Allocations

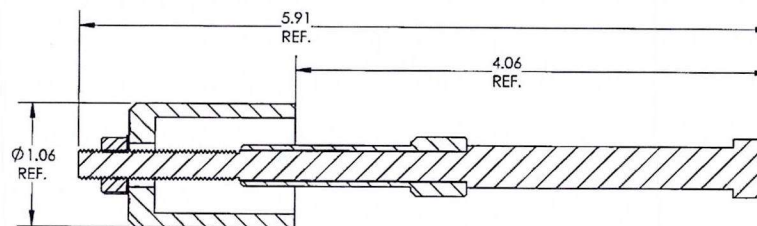
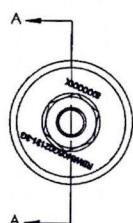
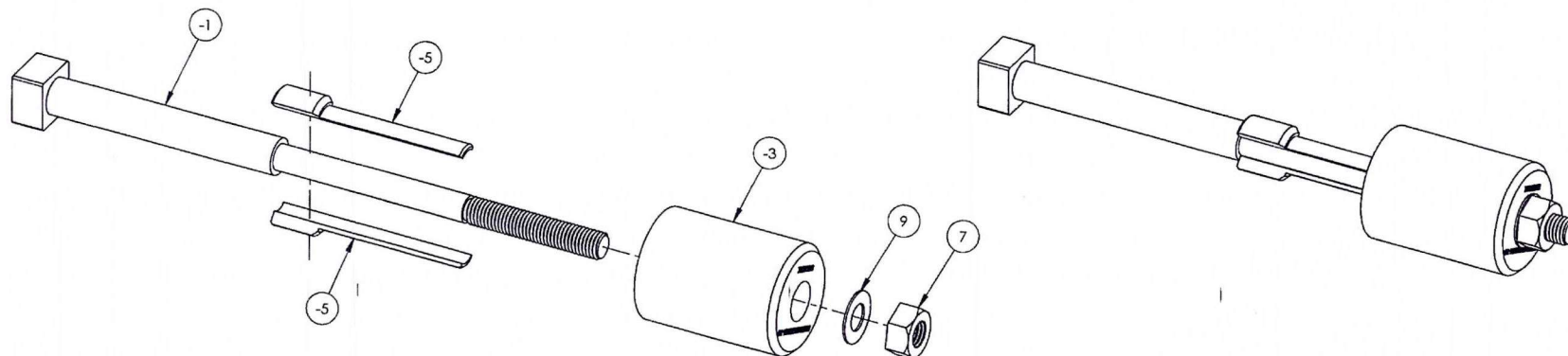
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	94191A150	2	24	0
	95229A420	2	96	0
	RBW6405G02131-3G-1	2	0	0
	RBW6405G02131-3G-3	2	3	0
	RBW6405G02131-3G-5	4	1	0

Part Specifications
Specifications could not be found.

Plex 2/6/19 8:38 AM Dart.Macdonald.Dara

ITEM #	QTY	PART #	TITLE	PG
-1	1	RBW6405G02131-3G-1	BOLT	2
-3	1	RBW6405G02131-3G-3	BELL	3
-5	2	RBW6405G02131-3G-5	QUARTER BELL	4
7	1	McMaster#94191A150	HEX NUT 1/4"-28 UNF GRADE 8	-
9	1	McMaster#95229A420	FLAT WASHER 1/4"	-

REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
1	CH'D TITLEBLOCK WAS RED BARN IS DART. -1 CH'D DIM WAS 4X.03 X 45° IS 4X R.34. -5 ADDED DIM (.338), CH'D DIM WAS 1.430 IS 1.45.	14-0205	10/31/2014	DJN	JAG
2	-1 AND -5 CH'D MATERIAL CALL OUT WAS 4140 Q&T IS 4140 Q&T / 4142 Q&T. -5 ADDED PART MARK FOR PAIRS NOTE.	15-0294	9/10/2015	RJC	JAG
3	-1 CH'D MAT'L WAS 4140 Q&T/4142 Q&T IS 4140/4142. ADDED HEAT TREAT RC 28-34. CH'D FINISH WAS CAD PLATE YELLOW QQ-P-416 TYPE II CLASS II IS ZINC PLATE ASTM B633 TYPE I SC2. -3 DELETED DIMS (.220), (2X .118). CH'D DIM WAS 1.12 IS 1.20. -5 CH'D MAT'L WAS 4140 Q&T/4142 Q&T IS 4140/4142. ADDED HEAT TREAT RC 28-34. CH'D FINISH WAS CAD PLATE YELLOW QQ-P-416 TYPE II CLASS II IS ZINC PLATE ASTM B633 TYPE I SC2. DELETED DIM 42°.	17-0161	6/23/2017	DPD	JAG
D	-1 & -5 MATERIAL 4140-4142 CHANGED FOR 4140-4142 Q&T Rc ADDED, TEMPLATE UPDATED	17-717	17.10.19	VM	WM



SECTION A-A

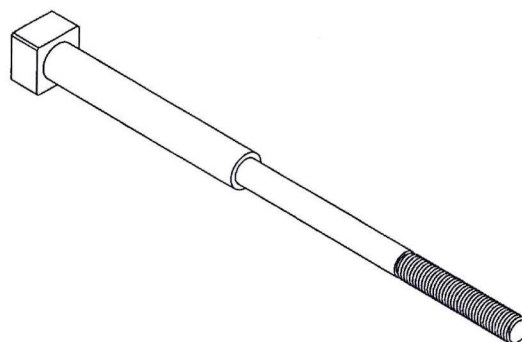
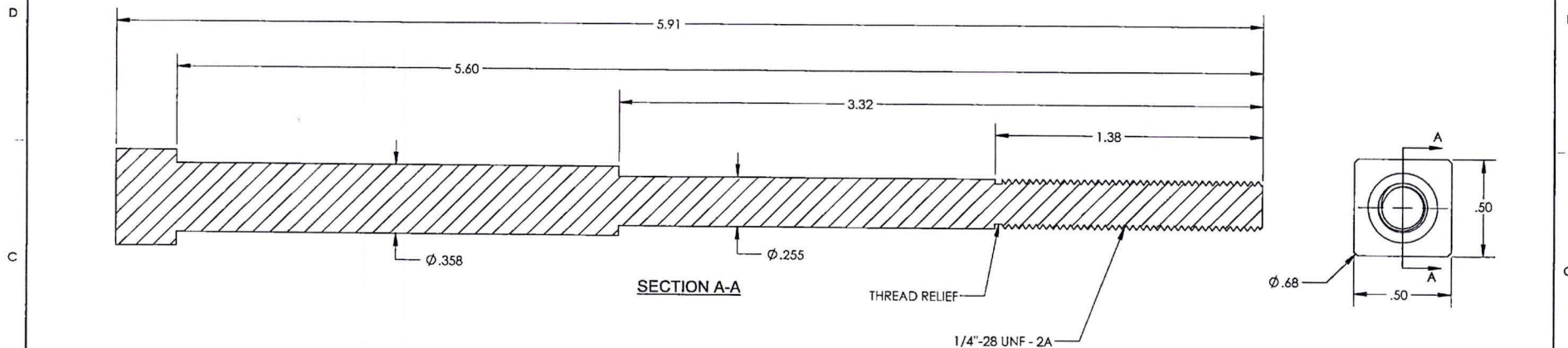
NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) SPEC: N/A
- 5) BREAK ALL SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) REF AGUSTA T/N: 3G6405G02131

RBW6405G02131-3G TAIL ROTOR BLADE DAMPER ATTACHMENT BUSHING REMOVAL

DART AEROSPACE Hawkesbury, Ontario, Canada	
TITLE TAIL ROTOR BLADE DAMPER ATTACHMENT BUSHING REMOVAL	
DWG NO. RBW6405G02131-3G	REV D
DESIGN BY: VM 10/19/2017	XXX ± .005 FRACTIONS & 1/8
DRAWN BY: VM 10/30/2017	XX ± .01 ANGLES ± 5°
CHECKED: SAC 10/30/2017	X ± .1 SURFACES ± 12°
MFG. APPR: VM 10/31/2017	1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED
APPROVED: VM 11/02/2017	2. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE: 10/30/2017	3. DIMENSIONAL LIMITS APPLY AFTER PLATING
SCALE: NTS	WEIGHT: N/A
SHEET 1 OF 4	
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8 7 6 5 4 3 2 1



RBW6405G02131-3G-1 BOLT

NOTES:

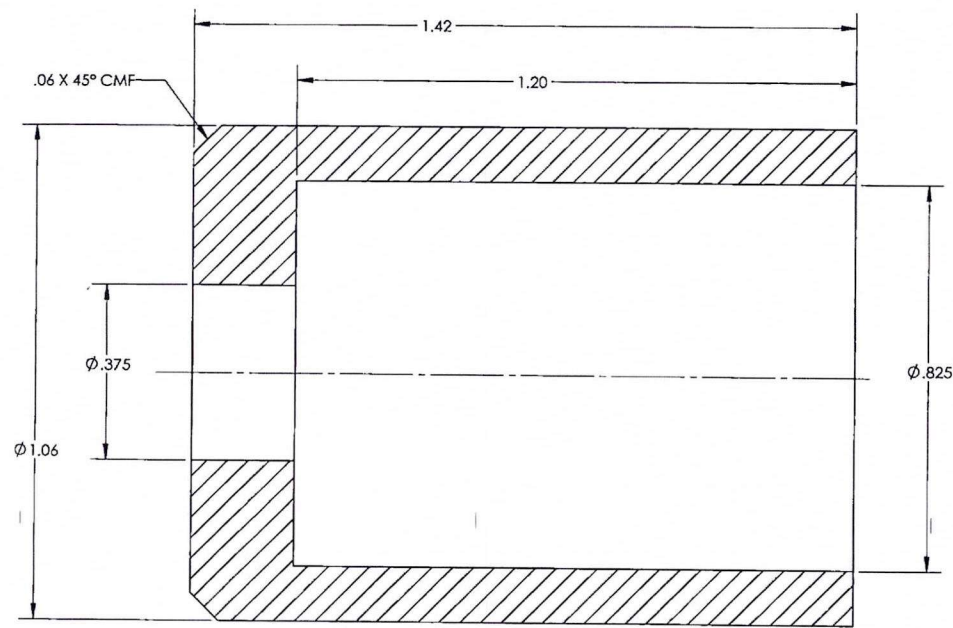
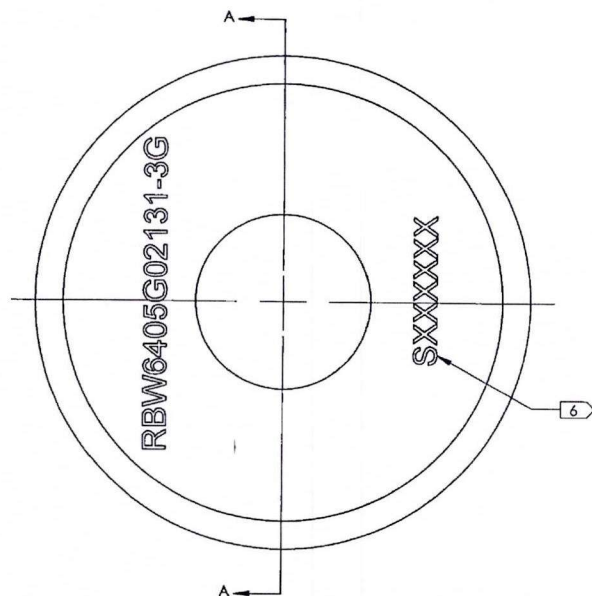
- 1) MATERIAL: AISI 4140/4142 Q & T
- 2) HEAT TREAT: 28-34 Rc
- 3) FINISH: ZINC PLATE
- 4) SPEC: ASTM B633 TYPE I, SC 2
- 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
- 6) IDENTIFICATION: N/A

DART AEROSPACE Hawkesbury, Ontario, Canada	
BOLT	
TITLE	
DWG NO. RBW6405G02131-3G-1	
DESIGN BY: VM 10/19/2017	XXX ± .005 FRACTIONS & 1/8"
DRAWN BY: VM 10/30/2017	.XX ± .01 ANGLES & 5°
CHECKED: SAC 10/30/2017	.X ± .1 SURFACES = 12.5°
MFG. APPR: DD 10/31/2017	1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED
APPROVED: WM 11/02/2017	2. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE: 10/30/2017	3. DIMENSIONAL LIMITS APPLY AFTER PLATING
SCALE: NTS	WEIGHT: 0.132 LBS
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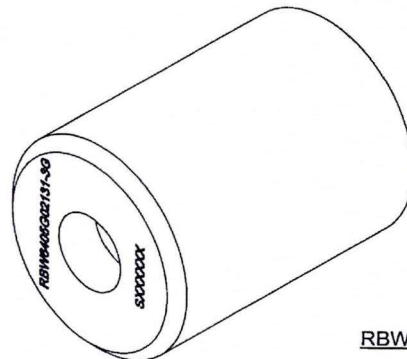
8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

D
C
B
A



SECTION A-A



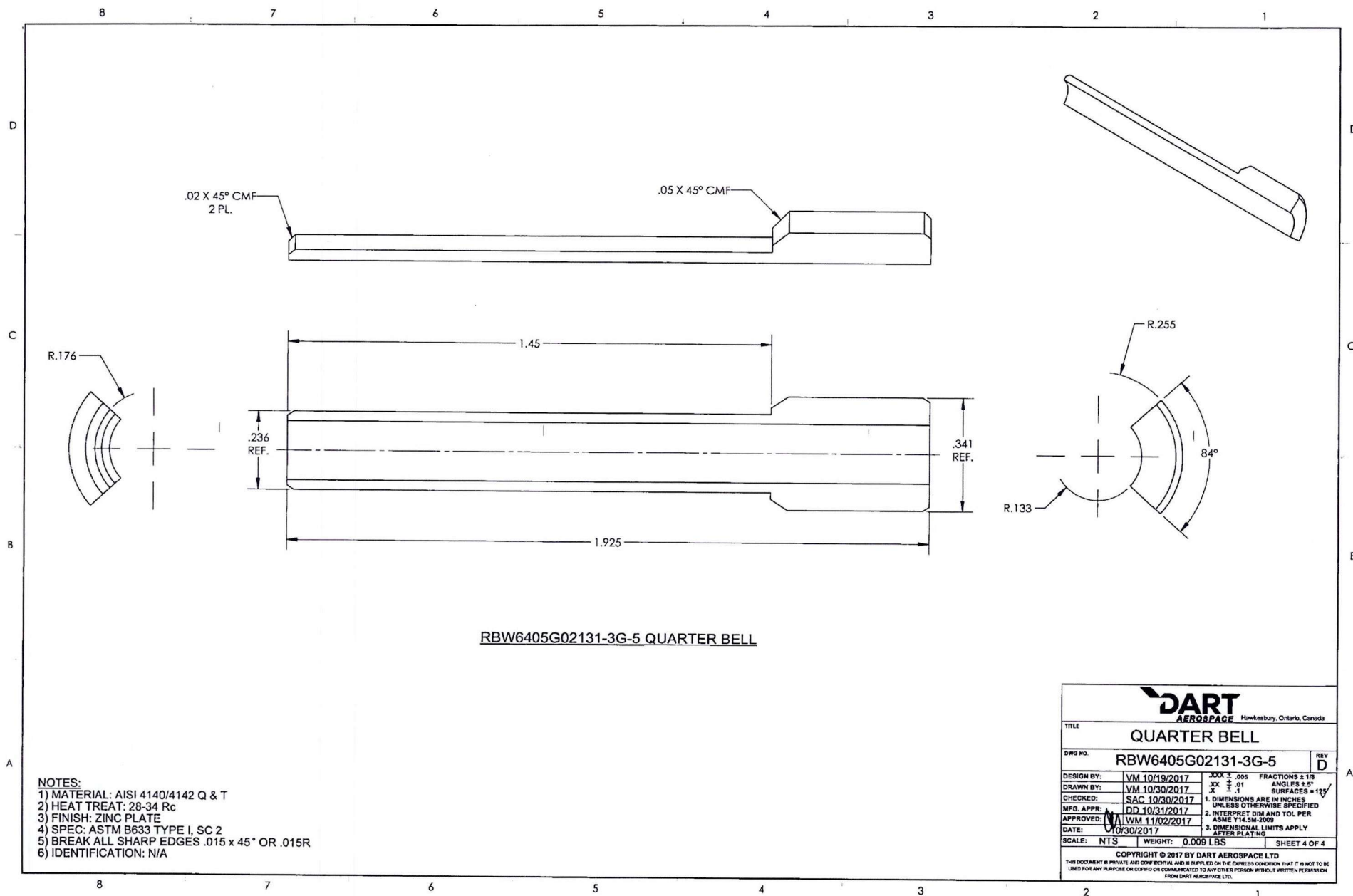
RBW6405G02131-3G-3 BELL

NOTES:

- 1) MATERIAL: 6061-T6
- 2) HEAT TREAT: N/A
- 3) FINISH: CLEAR ANODIZE
- 4) SPEC: MIL-A-8625, TYPE II, CLASS 1; WATER SEALANT
- 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
- 6) IDENTIFICATION: MACHINE ENGRAVE PER CAD FILE LATEST REV T/N & S/N, 0.010" DEPTH

DART AEROSPACE Howkerbury, Ontario, Canada	
TITLE: BELL	
DRG NO. RBW6405G02131-3G-3	REV D
DESIGN BY: VM 10/19/2017	XXX ± .005 FRACTIONS & 1/8
DRAWN BY: VM 10/30/2017	.XX ± .01 ANGLES & 1°
CHECKED: SAG 10/30/2017	.X ± .1 SURFACES = 12.5
MFG. APPR: WDD 10/31/2017	1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED
APPROVED: VM 11/02/2017	2. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE: 10/30/2017	3. DIMENSIONAL LIMITS APPLY AFTER PLATING
SCALE: NTS	WEIGHT: 0.057 LBS
SHEET 3 OF 4	
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8 7 6 5 4 3 2 1



Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					